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IS 6421 (1972): Perforators, Paper, Double Hole [PGD 14: Consumer Products and Allied Equipments]

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AMENDMENT NO. 1 MARCH 1996
TO
IS 6421 : 1972 SPECIFICATION FOR PERFORATORS, PAPER, DOUBLE HOLE

(*Page* 1, *clause* 5.1) — Substitute '500 *HV Min*' *for* '500 to 550 *HV*'.

(*Page* 2, *clause* 10, *second line*) — Delete the words 'and its wight'.

(LMD 15)

Reprography Unit, BIS, New Delhi, India

UDC 686.865.3

IS : 6421 - 1972
(Re (Reaffirmed 2003)

Indian Standard

SPECIFICATION FOR PERFORATORS, PAPER, DOUBLE HOLE

(Incorporating Amendment No. 1)

1. Scope — Specifies requirements of double hole paper perforators.

2. Types — a) Light duty, and

b) Heavy duty.

3. Terminology — For the purpose of this standard, nomenclature for various parts as indicated in Fig. 1 shall apply.

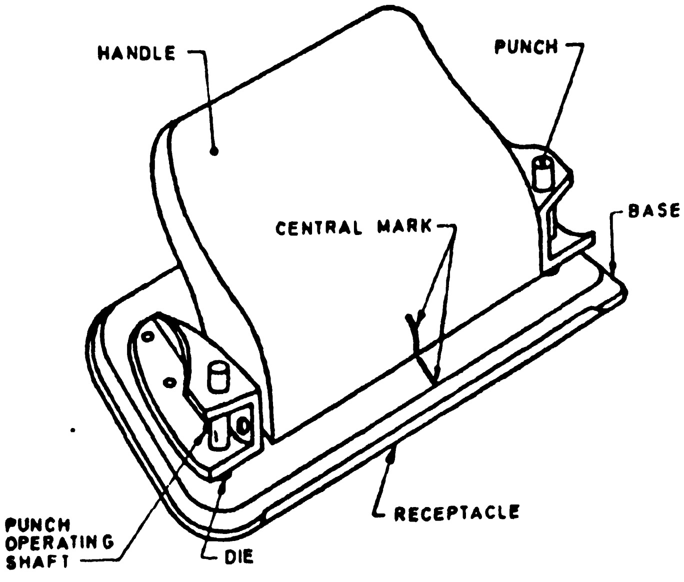

FIG. 1 PERFORATOR, PAPER, DOUBLE HOLE, LIGHT DUTY

BPD 34

4. Shape and Dimensions — As shown in Fig. 2.

5. Material — Different components shall be made of the following materials and shall satisfy the requirements mentioned therein.

5.1 *Punches* — Shall be made of carbon steel or alloy steel and shall have a hardness of 500 *HV Min*.

5.2 *Dies* — In case of light duty perforators the dies shall form a part of the base which shall be made from cold rolled steel suitably case hardened. For heavy duty perforators the dies may form a part of the base or an insert in the form of a carbon steel sleeve with a rigid fitting to the base.

5.3 *Punch Operating Shaft* — Shall be made of steel having a minimum hardness of 240 *HV*.

5.4 *Springs* — Shal. be made of spring steel which shall satisfy the performance requirements specified in **8**.

5.5 *Receptacle* — A suitable receptacle shall be provided below the punch hole for collection of cuttings which shall be easily removable. Light duty perforators shall be provided with receptacle at the base which shall be enamel painted, electroplated, galvanized or tinned.

5.6 *Handle* — Heavy duty perforator shall be made of cast metal or cold rolled steel sheet while light duty perforator shall be made of cold rolled steel sheet. The handle shall be of such design that there shall be no permanent set or break-down when the performance test is carried out as given in **7**.

5.7 *Paper Guide* — Heavy duty perforator shall be provided with paper guide. It shall be made of carbon steel strip having width 10 ± 5 mm and thickness 1.0 mm. It shall be bent at one end and graduated to provide for the centring of A-4, A-5, B-5, C-5 and A-6 sizes of the paper [*see* IS : 1064-1961 Specification for paper sizes (*revised*)].

Adopted 25 January 1972	© BIS 2002	Price Group 1

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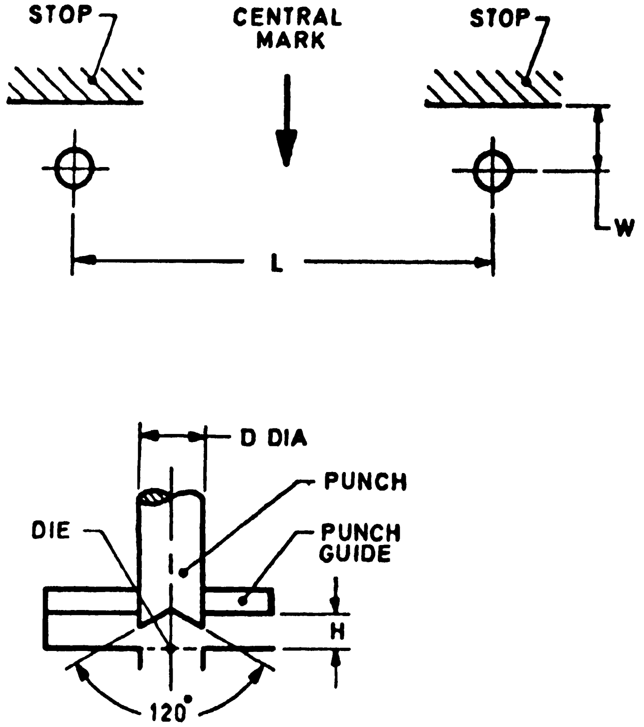

Type	L	W	D	H
Light duty	80.0 ± 0.5	12 ± 1	6.0 ± 0.5	1.5
Heavy duty	80.0 ± 0.5	12 ± 1	6.0 ± 0.5	3.0

All dimensions in millimetres.

FIG. 2 DIMENSIONS OF PERFORATOR, PAPER DOUBLE HOLE

6. Workmanship and Finish — Perforators shall be free from sharp edges (except the die and the punch), burrs, blemishes, cracks and other surface defects. The punching action shall be smooth and free from jerks and shall have no side play. The two punch shall operate and cut simultaneously. For orientation purpose, the punch shall have a central mark on the body between the two punches.

6.1 *Finish* — Unless otherwise specified exterior surfaces of the perforator with the exception of machined and other operating parts shall be finished with stove enamel paint. The paint shall adhere uniformly and shall not readily peel or chip. The paint shall be such as to withstand at a temperature of 130°C for one hour without appreciable discolouration. The machined and other operating parts shall be oiled.

7. Performance Test — The perforator shall punch a bunch of 10 sheets of 75 g/m^2 paper for light duty perforator and 20 sheets of 75 g/m^2 paper for heavy duty perforator simultaneously by pressing the handle down. The force shall be applied at the centre of the handle with even pressure in downward direction, approximately, vertical to the base. The resulting perforations shall be entirely and neatly punched out without being torn or ragged. The form of punch hole shall be even and circular. When the handle is released, the spring and punch shall automatically return to its original position. There shall not be any permanent bending of parts nor any damage that will affect the serviceability of the perforator. The test shall be repeated for 100 times.

8. Test for Spring — The handle shall be pressed for 200 times for light duty perforators and 500 times for heavy duty perforators without putting the paper sheets between punch and die. There shall not be any permanent set on the spring, when measured at the free end of the handle.

9. Drop Test — With the base at an angle between 30 and 60° from horizontal the perforator shall be dropped three times from a height of one metre on concrete floor or slab so as to strike on one end. The test shall be repeated the same number of times with the perforator striking at the opposite end. The perforator shall not be damaged.

10. Marking — Each perforator shall be clearly and indelibly marked with the manufacturer's name, initials or registered trade-mark.

10.1 *ISI Certification Marking* — Details available with the Indian Standards Institution.

11. Packing — Each perforator shall be suitably preserved and packed in appropriate cartons. They may also be packed as agreed to between the purchaser and the supplier.

EXPLANATORY NOTE

This edition 1.1 incorporates Amendment No. 1 (March 1996). Side bar indicates modification of the text as the result of incorporation of the amendment.

Reprography Unit, BIS, New Delhi, India